

Work Order ID 66835

Monday, February 28, 2011 11:41:55 AM



Page 1

Item ID: D2565-111

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 2/28/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2565	Rev E								
100	Punch ends and deburr as per dwg	0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110	Small Fab	0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

SB 11/03/07

SB 11/03/08

SB 11/03/08

PTO

87

87

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2S6S-111 PAR #: _____ Fault Category: Small Job NCR: Yes No DQA: _____ Date: 11/03/09
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 11/3/11

NCR: <u>66835</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/03/09</u>	<u>100</u>	<u>after punching nest saw material was damaged R.C process</u>	<u>[Signature]</u> <u>11/03/09</u>	<u>Scrap destroy No replace</u>	<u>SP</u> <u>11/03/09</u>	<u>8</u> <u>11/03/09</u>	<u>[Signature]</u> <u>11/03/09</u>	<u>[Signature]</u> <u>11/03/09</u>

NOTE: Date & initial all entries

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Item ID:	D2565-111	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Strut					
Start Date:	2/28/2011	Start Qty:	8.00		Cust Item ID:	
Required Date:	3/4/2011	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M113951</i> Memo START TIME: <i>11:50</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>12:20</i>	0.00 0.00				<i>7</i>	<i>BR</i>	<i>11-3-10</i>	
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>11/3/10</i>	<i>SP</i>	<i>(70)</i>	
150 Packaging Packaging	Identify as per dwg & Stock Location: <i>270</i> Memo	0.00 0.00				<i>11/3/10</i>	<i>SP</i>	<i>(70)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2565-111

Accept

Setup Start

Revision ID:

Stop

Item Name: Strut

Start Date: 2/28/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/11
MF
11-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, February 28, 2011 11:42:03 AM

Page 1

Work Order ID: 66835

Parent Item: D2565-111

Parent Item Name: Strut



Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: E01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC
IPP: E06.05.03 Change level 2/8 to QC5 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased		No		100	f	37.9459	1.1375	9.578947			
304 RD Tube .750 x .049W													

Location	Loc Qty	Loc Code
MAT	32.3259	
108498	0	
110113	0	
115010	12.264255	
116108	4.08294	
116720	15.978705	
MAT014	0.00003	
115990	0.00003	
MAT017	5.62	
109314	4.33	
110113	1.29	

M 117030

12

SB 11/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

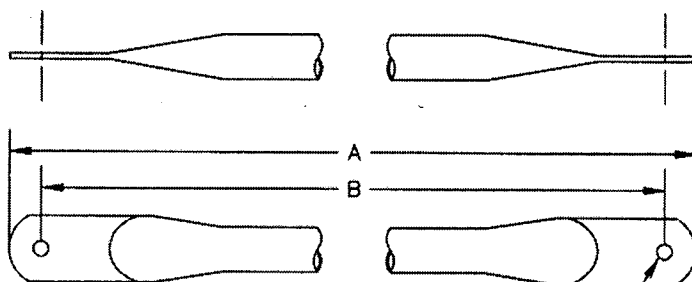
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04 05 05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66835

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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